

Date: Thursday, 11/06/2009 11:54:49 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER RAIL
Job Number : 48488	
Estimate Number : 13489	
P.O. Number :	Part Number : D37671
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3767 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42874	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09-06-11</u>	
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added drilling tooling 08-08-26 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
		(10X)
Comment: Qty.: 2.9313 f(s)/Unit Total : 29.3129 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M111029</u> <u>M-L 09/06/15</u>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		(10X)
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3767 2-drill holes thru to finish size as per dwg D3767 Using DT9410,Locate tube on stop labelled #2 and then drill holes labelled #2 3- deburr <u>M-L 09/06/15</u>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
		(10X)
Comment: INSPECT WORK TO CURRENT STEP <u>S 09/06/15</u>		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		(X10)
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>UMP 09/06/15</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: UPPER RAIL

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Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10
09/06/15

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 254

9/6/15

10x
SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16

Job Completion



MF
09-06-16

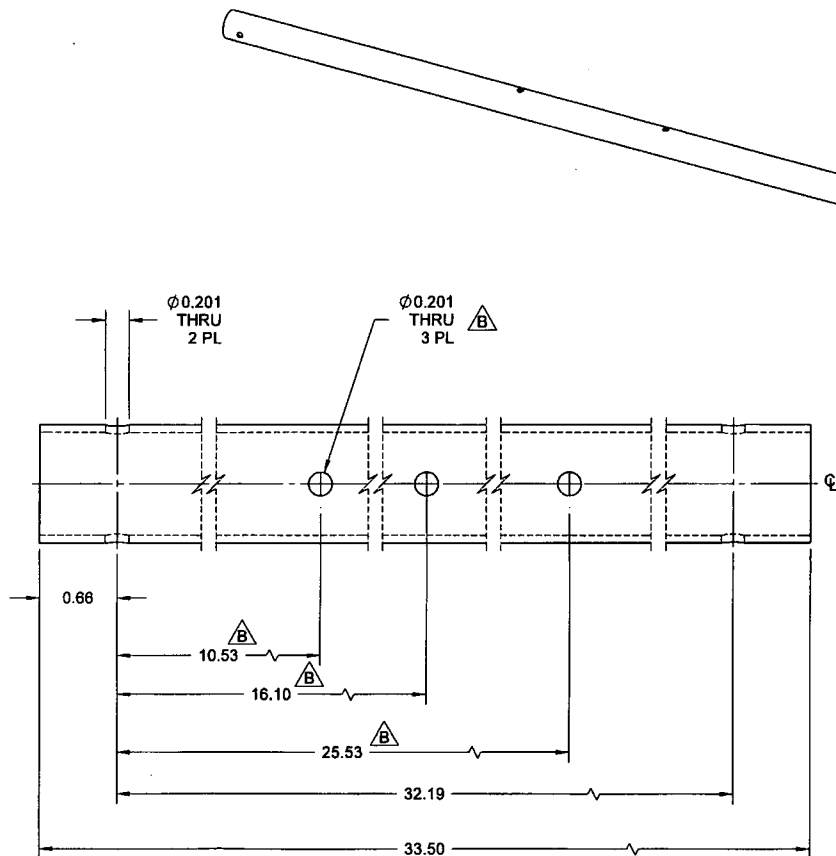
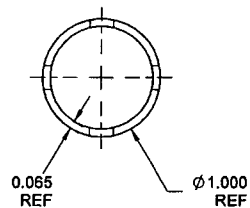
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3767-1 UPPER RAIL

RELEASED
08-07-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

B	CHANGE HOLE SIZE TO 0.201, SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3767	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		UPPER RAIL	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	